

Work Order ID 79671

January-31-12 9:22:32 AM

slip Friday 03/02

79671

Page 1

Item ID: D4007-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 1/31/12

Start Qty: 3.00 *3*

Cust Item ID:

Required Date: 2/01/12

Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4007

A

100

0.00

100

Purchasing

Purchasing

2004 . 063

Memo

Issue P/O:

Purchase part as per Dwg D4007

Possible Supplier: GFI

Material release note required

100 winter set . A
0.00 cut as per Dwg
kw pos kw
2- Debur A

B12-1-31

(6)

110

Receive & Inspect for Damage & Mat'l Certs

101 - QC2
0.00

110

Packaging

Packaging

Memo

102 - QC6
0.00

B12-1-31

S12/02/01 (8)

103 small FAB
Bend as per Dwg .

S12/02/02

pro
next page

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

S12/02/02
0.00

(x5)

(x6)

W/O: 79671		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4007-3 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA: Ant Date: 12/2/3
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: UL Date: 12/3/2

NCR: 12-1182		WORK ORDER NON-CONFORMANCE (NCR) 4390						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/02	103	1 piece scrap 1 side out of tolerance try out for set-up R.C Process	S 12/02/02 007042	Scrap - destroy N/A replace	S 12/02/02	S 12/02/02	S 12/02/02 007042	S 12/02/02

NOTE: Date & initial all entries

Work Order ID 79671

79671

Page 2

January-31-12 9:22:32 AM

Item ID: D4007-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 1/31/12

Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/01/12

Req'd Qty: 3.00

3

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

5 12-22

140

~~QC3~~ Inspect Part Finish

0.00

140

QC

QC7

Memo

0.00

Quality Control

5X Ø M/L 12/02/02

150

Identify as per dwg & Stock Location: 107

0.00

150

Packaging

Memo

0.00

Packaging

11/2/12 (5)

Work Order ID 79671

79671

Page 3

January-31-12 9:22:32 AM

Item ID: D4007-3

Accept

N900040100

Setup Start

NS1

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Stop

NS2

Item Name: Support

Start Date: 1/31/12

Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/01/12

Req'd Qty: 3.00

3

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/2/3
ME
12-02-02

Picklist Print

January-31-12 9:22:32 AM

Page 1

Work Order ID: 79671

Parent Item: D4007-3

Parent Item Name: Support

Start Date: 1/31/12

Required Date: 2/01/12

Start Qty: 3.00

Required Qty: 3.00

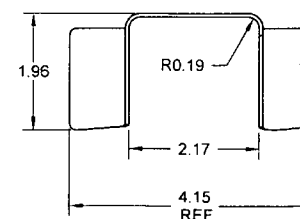
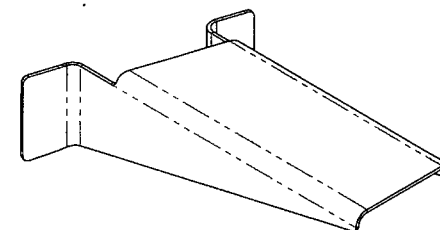
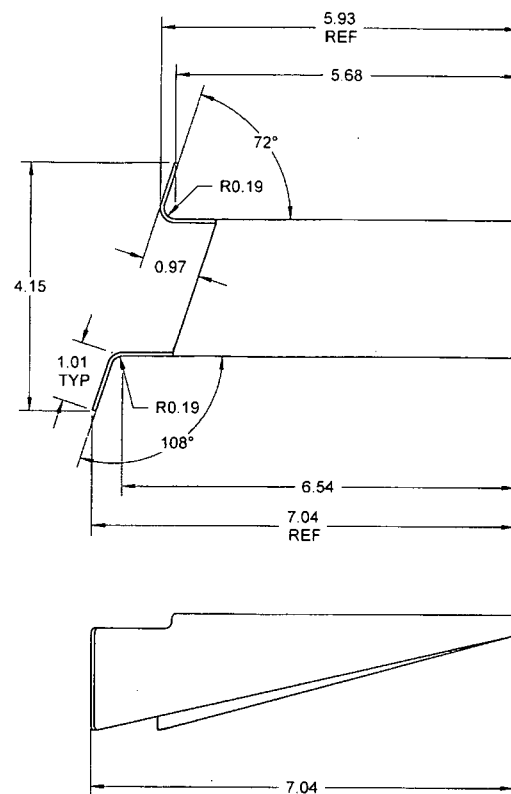
Comments: IPP rev A 09.12.18 new Issue Prelim EC verified: DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4007-3P Support		Purchased	No			110	Each	0.0000	1	3			

~~1061~~
2074 .063

117382

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-1	JCA-M47-2-02



D4007-1 TOP SUPPORT BRACKET

RELEASED
2010-05-05

- NOTES:
- 1) MATERIAL: MADE FROM D4007-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.17 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.02.05			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWING NO. D4007	SHEET 1 OF 5
TITLE SUPPORT	SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

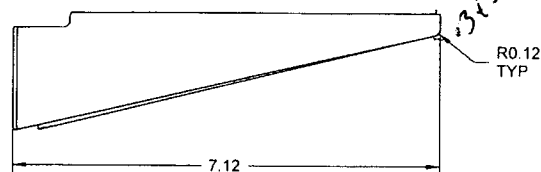
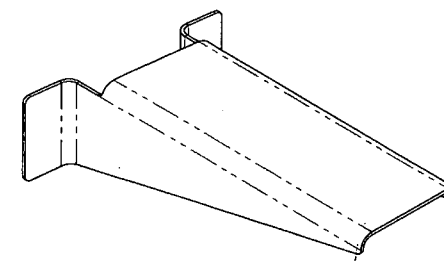
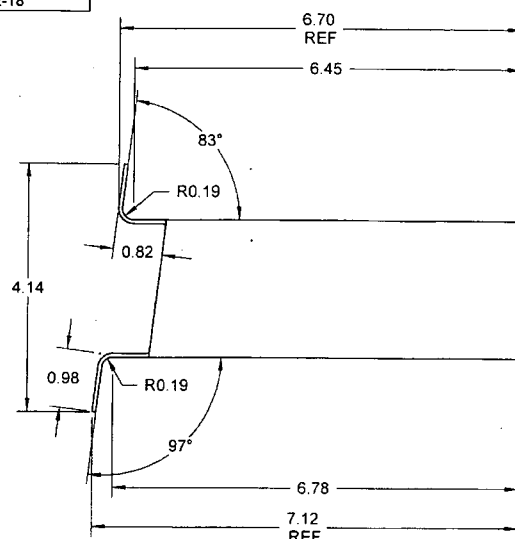
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

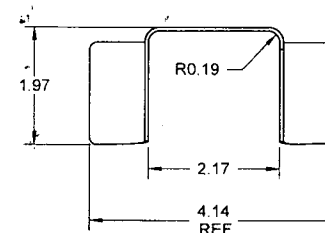
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-3	JCA-M47-2-18



1.504



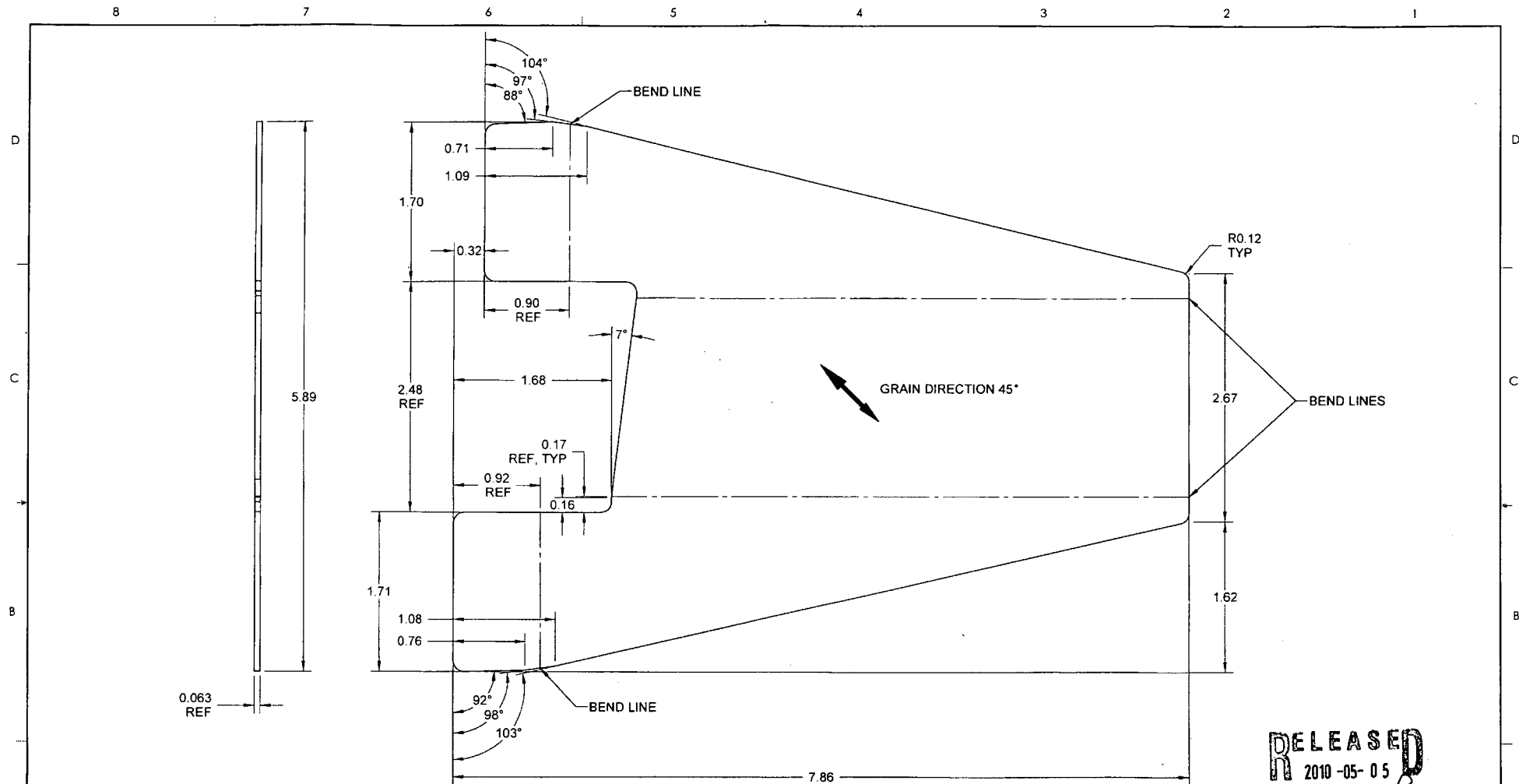
D4007-3 TOP SUPPORT BRACKET

RELEASED
2010-05-05
JMP

NOTES:

- 1) MATERIAL: MADE FROM D4007-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT	NTS
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D4007-3F FLAT PATTERN

NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

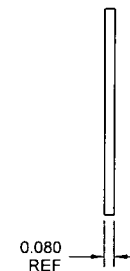
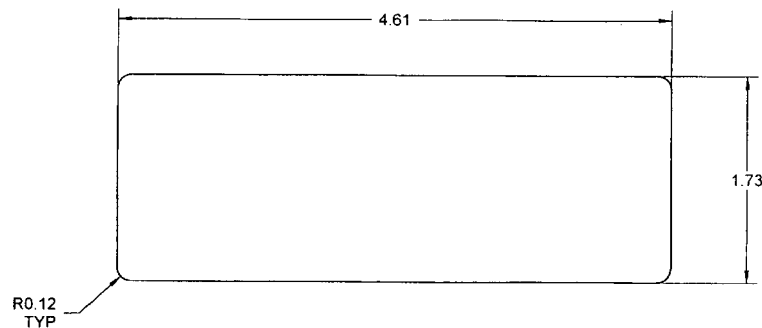
6) IDENTIFICATION: N/A

7) WEIGHT: 0.19 lbs

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RELEASED
2010-05-05
MD

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-5	JCA-M47-2-24



D4007-5 PACKER

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4007	SHEET 5 OF 5
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RELEASED
2010-05-05
MP

FIRST ARTICLE INSPECTION CHECKLIST

PART AEROSPACE LTD		Work Order: 79671
Description: Support		Part Number: D4007-3
Inspection Dwg: D4007-3		Rev: A
Page 1 of 1		

☒ First Article ☐ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
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1.71	± .030		1.714	2		V	B02
2.49	± .030		2.478	2		V	
1.70	± .030		1.696	2		V	
.85	± .030		.865	2		V	
1.95	± .030		1.955	2		V	
5.88	± .030		5.88	2		V	
7.65	± .030		7.658	2		V	
2.66	± .030		2.662	2		V	
1.63	± .010		1.613	2		V	
.063	± .010		.061	2		V	

Measured by: JB	Date: 12-1-31
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Audited by: S	Date: 12/2/31
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A			KJ/LM	